

Date: Wednesday, 11/21/2007 12:51:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR RH
Job Number	: 35946		
Estimate Number	: 11225		
P.O. Number	: <i>N/A</i>	Part Number	: D32803
This Issue	: 11/21/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Drawing Number	: D3280 REV. <i>BC</i>
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 35245	Drawing Revision	: <i>BC</i>
		Material	: <i>N/A</i>
		Due Date	: 11/28/2007
Written By	:	Qty:	5
Checked & Approved By	:	Um:	Each
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

F6006 701

lexan black



M105952



Comment: Qty.: 4.0000 sf(s)/Unit Total: 20.0000 sf(s)
 lexan black

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



x5

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 07/11/22

PTO →

3.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev. C
 Folio Rev. B

BB 07/11/23

x5

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



BB 107/11/26



PTO →

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 107/11/26

x5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/03	4	1 - Mould Mark 1 - Dirt in Tool. R.C. operator errors	<u>AS</u> <u>AS</u>	Scrap & replace. Scrap & replace.	<u>BB</u> <u>07/11/22</u>	<u>BB</u> <u>07/11/26</u>	<u>AS</u> <u>07/11/26</u>	<u>BB</u> <u>07/11/26</u>

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:40 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR RH

Job Number: 35946

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

OK 02/11/26 AS

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

OK 02/11/26 AS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 272

AS 02/11/28 (XS)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 02/11/30

Job Completion



U 07-11-30

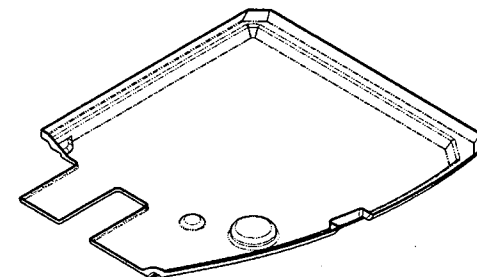
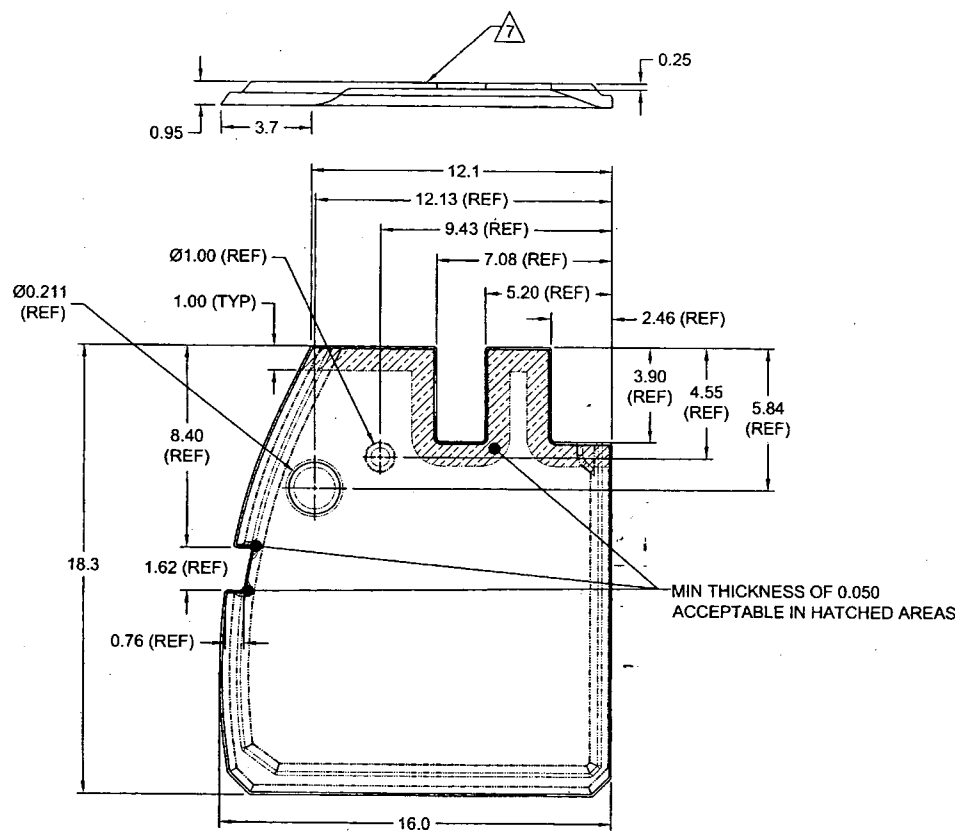
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3280-1 FLOOR PROTECTOR

D3280-1 NOTES:

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	LE		
CHECKED	PA		
MFG. APPR.	LA		
APPROVED	SH		
DE APPR.	SH		
DATE	07.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

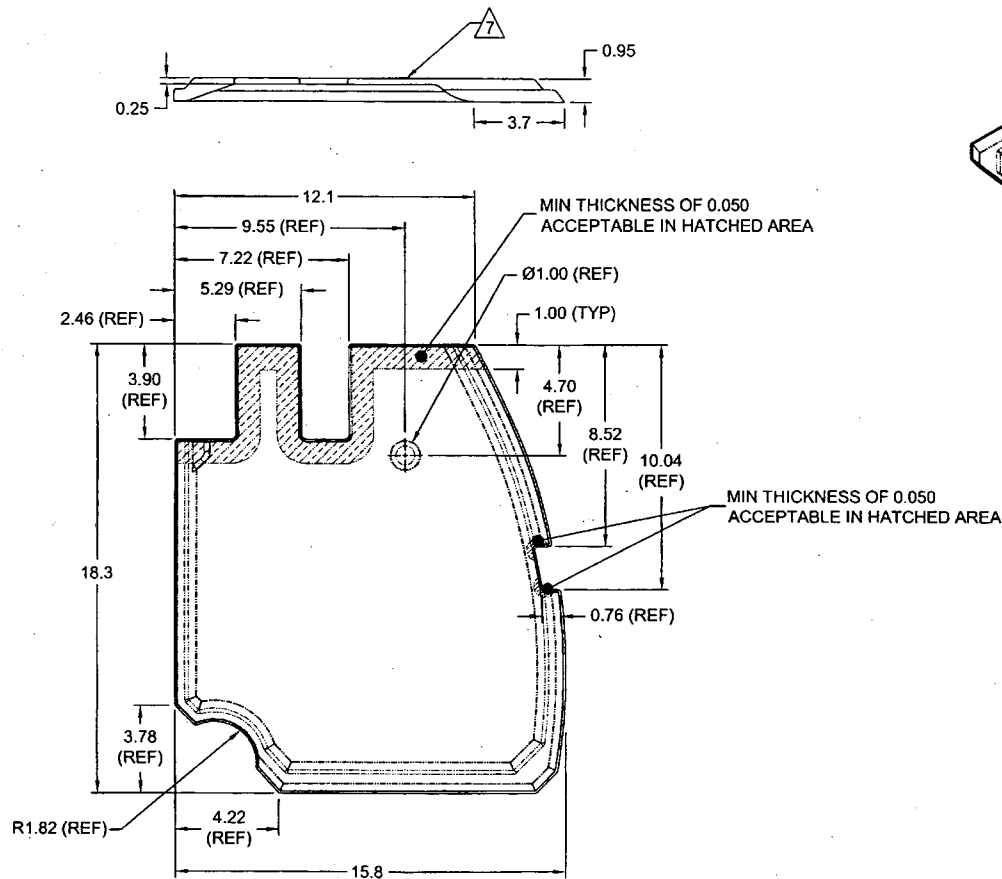
DRAWING NO. D3280
REV. C
SHEET 1 OF 2

TITLE FLOOR PROTECTOR
SCALE NTS

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07-11-06

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NO. 35944



D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	92	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	ED	D3280	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.12	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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07.11.06

DART AEROSPACE LTD		Work Order:	35846
Description: R72 FLOOR PROTECTOR RH.		Part Number:	D 3280-3
Inspection Dwg: D 3280 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16"</u>	✓		Gauge	
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 07.11.23

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.100	18.4	✓		TAPE	
15.8	.100	15.9	✓		TAPE	
12.1	.100	12.125	✓		TAPE	
.95	.030	.973	✓		CAL	
.75	.030	.774	✓		CAL	

Measured by: DL Date: 07.11.26

Audited by: DL Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Handwritten signature]